



Astro-Sol N

OVERVIEW

ASTRO-SOL N is a soluble oil concentrate. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium.

FEATURES & BENEFITS

- Low Foaming
- Mild Pleasant Odor
- Excellent Corrosion Inhibition
- Long Lasting
- Excellent Hard Water Stability
- Operator Friendly
- Sulfur, Chlorine and Phosphorous Free
- Provides Excellent Finish

APPLICATIONS

ASTRO-SOL N is designed for use in all metalworking applications such as CNC milling, turning, drilling, tapping and grinding.

RECOMMENDED CONCENTRATION

| Application | Concentration | Ratio | Refractometer |
|--------------------------------------|---------------|-------|---------------|
| Miling, Driling, Turning | 5% | 1:20 | 6.0 |
| Centerless, ID, OD, Surface Grinding | 4% | 1:25 | 4.8 |
| Tapping, Sawing, Reaming | 10% | 1:10 | 12.0 |

MIXING

| | | | | | | | |
|---------------|------|------|------|------|------|------|------|
| Concentration | 4% | 5% | 6% | 7% | 8% | 9% | 10% |
| Ratio | 1:25 | 1:20 | 1:17 | 1:14 | 1:12 | 1:11 | 1:10 |
| Refractometer | 4.8 | 6.0 | 7.2 | 8.4 | 9.6 | 10.8 | 12.0 |

TYPICAL PROPERTIES

| | |
|-------------------------|-------------------|
| Appearance-Concentrate | Dark Amber liquid |
| Appearance- Dilution | Opaque White |
| Residual Film | Soft, fluid |
| pH @ 20:1 | 9.0 ± 0.2 |
| Specific Gravity @ 60°F | 0.90 ± 0.03 |
| Lbs/ gal | 7.5 ± 0.1 |
| Flash Point, COC °F | 355 |

Material Safety Data Sheets are available for all products.
 All reasonable care has been taken to ensure
 that the above information is accurate as of the date of printing.